

Date: Wednesday, 10/09/2008 3:41:17 PM
 *User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MAINTENANCE STEP, LH
Job Number	: 41942		
Estimate Number	: 11283		
P.O. Number	:	Part Number	: D3436043
This Issue	: 10/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3436 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 39506	Drawing Revision	: A
Written By	:	Material	:
Checked & Approved By	: <u>NO 08.9.10</u>	Due Date	: 20/09/2008
Comment	: Est .A 05.05.11 New Issue KJ/JLM	Qty:	2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34361	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1	D3436-1	Clamp	B41943
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Signature 08.09.15 ² #

2.0	D34363	Left Step
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LH Step

Pick:

Qty Part Number Description Batch

1	D3436-3	LH Step	B41944
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Signature 08.09.15 ² #

3.0	D34365	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

4	D3436-5	Bushing	B23357
---	---------	---------	--------

Signature 08.09.15 ² #

4.0	D34367	Cap
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1	D3436-7	Cap	B38196
---	---------	-----	--------

Signature 08.09.15 ² #

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:41:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, LH

Job Number: 41942

Part Number: D3436043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A
Qty Part Number Description Batch
A/RN/A 4130 Welding Rod M102226

Weld left step D3436-7 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch
A/RN/A 4130 Welding Rod M102226

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch
A/RN/A 4130 Welding Rod M102226

08-09-16 12

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

Slit part D3436-041 on bandsaw as per Dwg D3436

08-09-16 12

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-07-16 12

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-09-16 42KH

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

Done at step #5.5

8/6/16

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

→ M108496 FL 08/09/16 (2)

START TIME:

12:45pm

OVEN TEMPERATURE:

400°F

910 08-09-16 42KH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:41:17 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, LH

Job Number: 41942

Part Number: D3436043

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

1:15pm

08-04-16

x2LH

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/18

12.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description Batch

2 D3436-9 Pad

A/R N/A Contact Cement

Batch

35490

10/09/09

10/09/18

10/09/17

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/18 x2LH

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51212

10/09/18

(2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



10/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

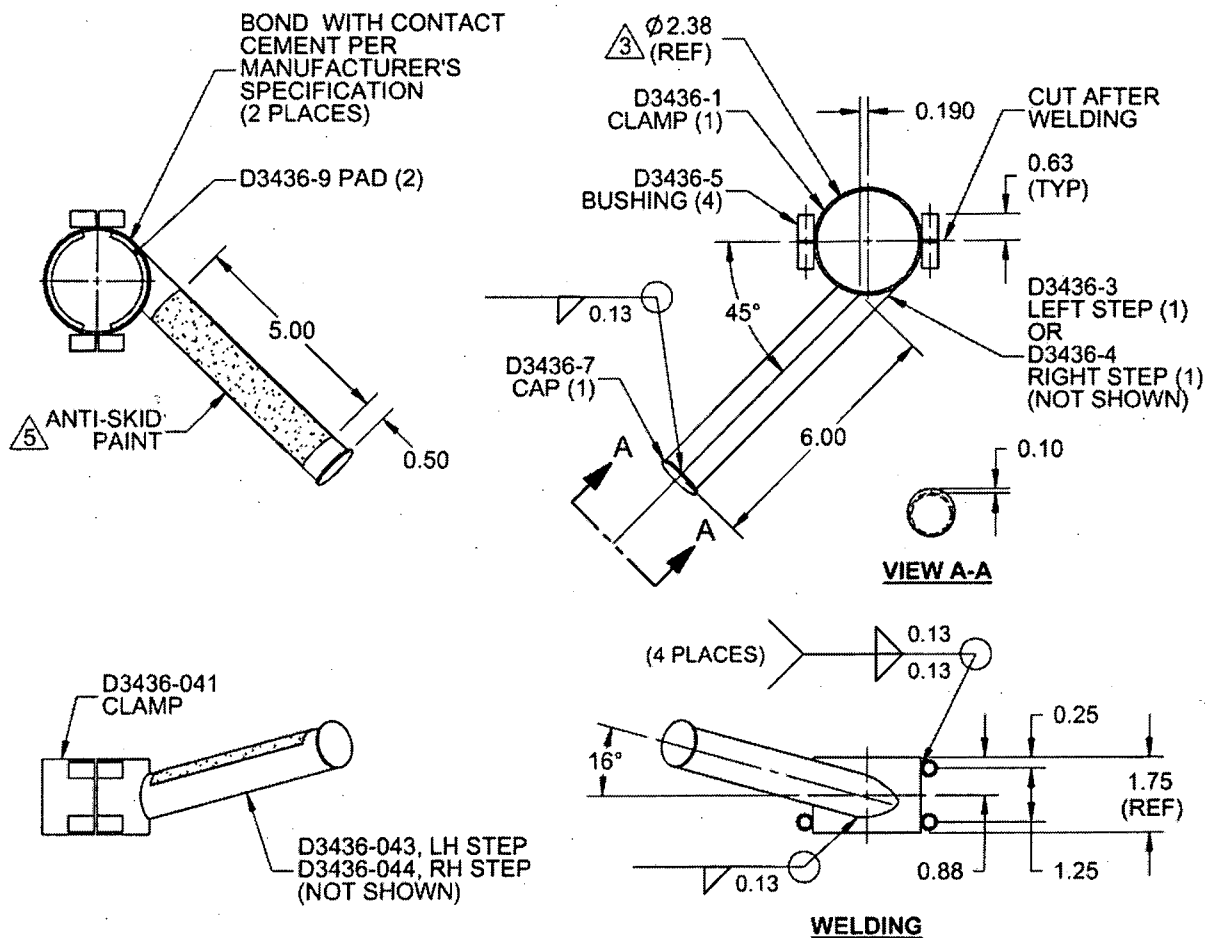
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>///</i>	APPROVED <i>///</i>	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED05-05-27 *///*

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WORK ORDER

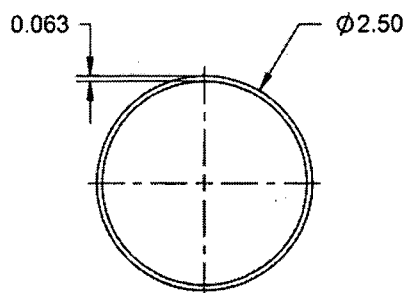
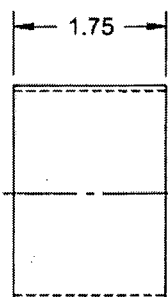
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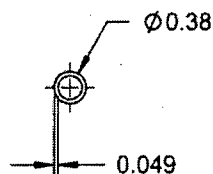
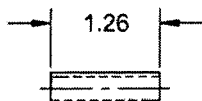


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CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/-5. GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 H

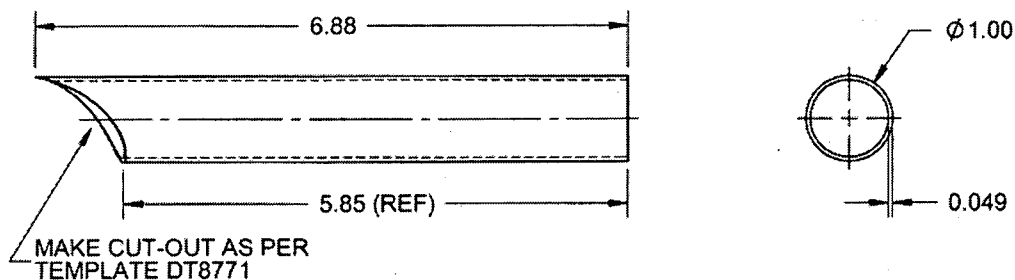
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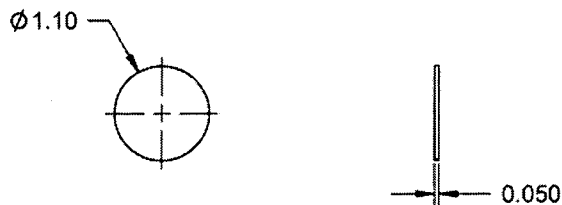
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CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 H

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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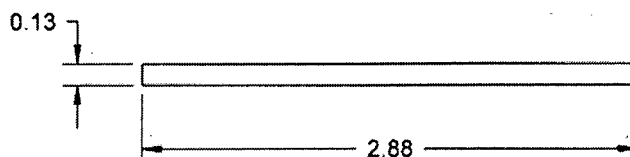
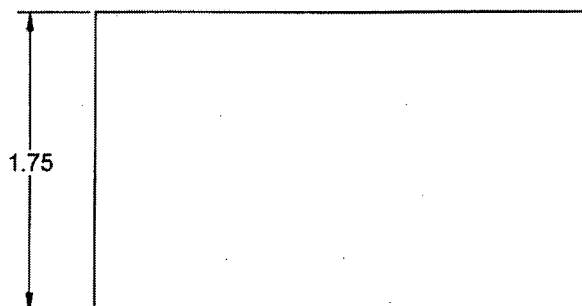
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED

05-05-27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Date: Friday, 20/06/2008 8:10:56 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3436-044 TO 043
Job Number : 39975	
Estimate Number : 10804	
P.O. Number :	Part Number : D3436043
This Issue : 20/06/2008 S.O. No. :	Drawing Number : NCR08-052
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 27/06/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D3436-044 B38181

RE-IDENTIFY AS D3436-043 USING NEW B/N
 PER NCR 08-052

ST 272

SS 08/06/20

(XU)

2.0	D3436044	Step RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Step RH

SS 08/06/20

(XU)

3.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/06/23

Job Completion



MF 08-06-20